

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008574**Date Inspected:** 29-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Zhi Jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY #3

Magnetic Particle Inspection

This Q.A Inspector performed Magnetic particle testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The member are identified as the Floor beam. The welds Designation are as follows.

FB009-025-004, 013, 014, 022, 029, 030; FB10-023-002, 013, 014, 021, 022,029; FB012-027-002, 013, 014, 021, 022, 048, 045; FB009-27-004, 013, 022, 030, 044, 047, 048; FB027-008-146, 149, 113, 076, 097, 104, 105, 089, 090, 098, 099, 110, 084, 085, 074, 075, 050, 051, 052, 053, 054, 055, 056, 057, 127.

This QA Inspector randomly observed the following work in progress.

Bay#10

FCAW welding process of the weld joint 9 located on PCM SSD1-FESA3-1D/D. Welder is identified 040338

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

ZPMC QC is identified Wing Chuanging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F

FCAW welding process of the weld joint 18 located on PCM SSD1-FESA3-1D/D. Welder is identified 040345 ZPMC QC is identified Wing Chuanging. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F.

This QA Inspector randomly observed the following work in progress.

Bay#11

SAW welding process of the weld joint 53A located on PCM ESD1-FASA4-2A/E. Welder is identified 041716 ZPMC QC is identified LILIN. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3C-S2

Bay#10

FCAW welding process of the weld joint 7A located on PCM SSD1-FCSA3-1B/C. Welder is identified 053869 ZPMC QC is identified YU ZHI LAI. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-TC-U5-F.

Bay#10

FCAW welding process of the weld joint 23 located on PCM NSD1-A26-A/B. Welder is identified 057244 ZPMC QC is identified GAO ZHI CHUN. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P5-F

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer